

Date: Thursday, 05/02/2009 9:19:55 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RIB/ GUSSET ASSY
Job Number	: 45506		
Estimate Number	: 13651		
P.O. Number	:	Part Number	: D3826041
This Issue	: 05/02/2009 S.O. No. :	Drawing Number	: D3826 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 44756	Material	:
Written By	:	Due Date	: 12/02/2009 Qty: 4 Um: Each
Checked & Approved By	: <u>JUD 09.02.05</u>		
Comment	: Est Rev:A 08-12-01 new issue DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22351	Basket Rib
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Basket Rib

batch: B45503 → 4x

SY 09/02/18

2.0	D2325	Support Gusset (350 Basket)
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Support Gusset (350 Basket)

batch: B43289 → 8x

SY 09/02/18

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- use DT9434 to assemble D2325 support gusset together

2- locate D2325 on rib and weld as per dwg D3826

A/R ER316 S.S. Rod Batch: M108775

SY 09/02/19 (4x)

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 09.02.19 (4)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

PD 09.02.19 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 05/02/2009 9:19:55 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB/ GUSSET ASSY

Job Number: 45506

Part Number: D3826041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Basket c.*

*PD 09-02-19*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/02/2009*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 09-02-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

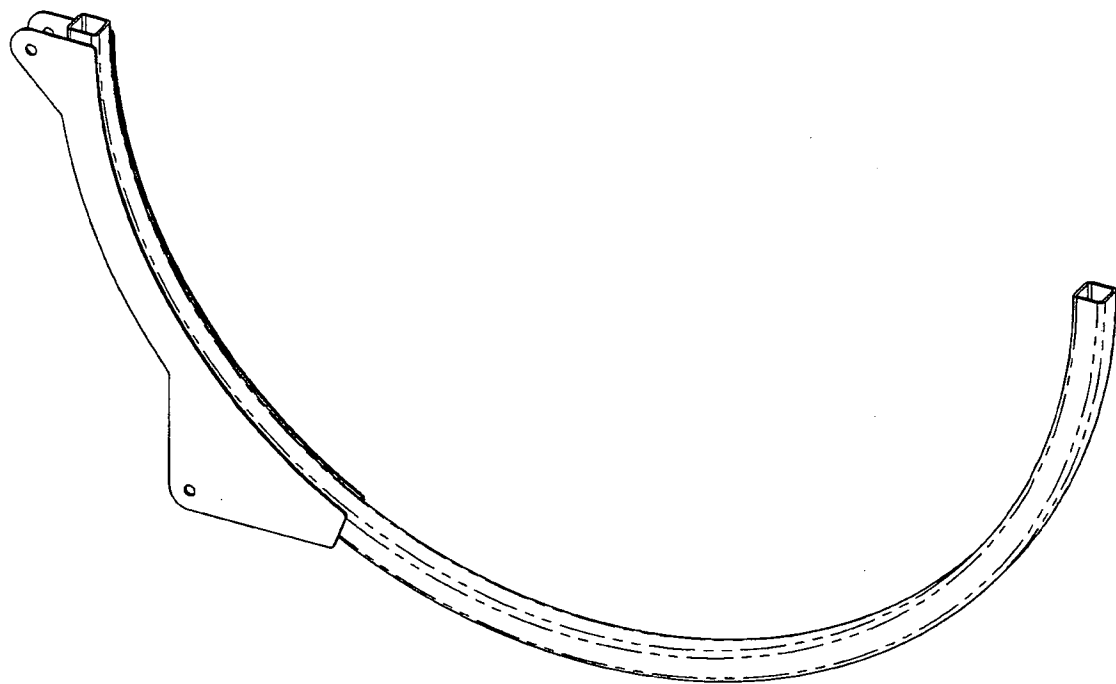
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSEMBLY
2	1	D2235-1	RIB
3	2	D2325	SUPPORT GUSSET



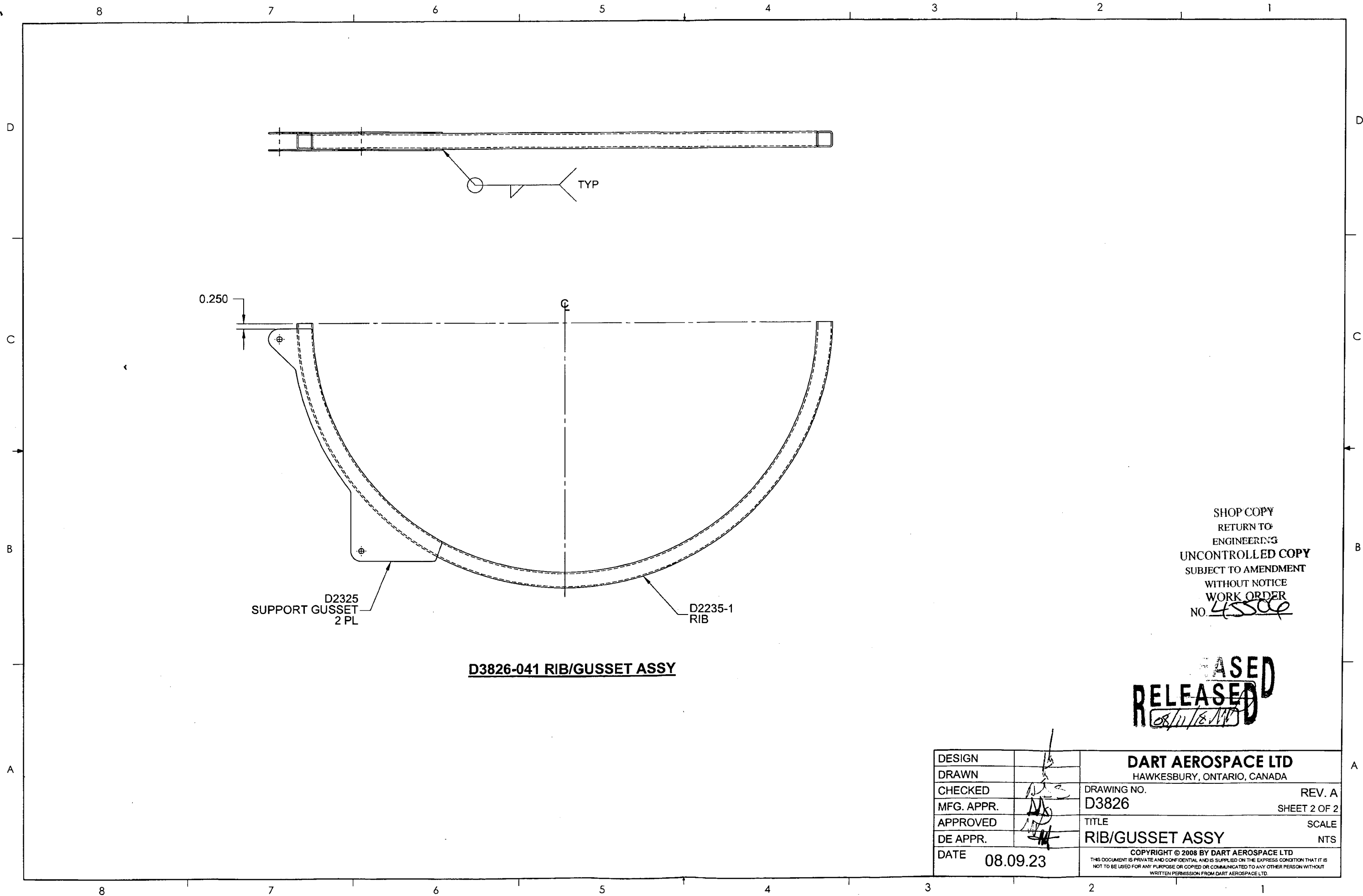
**D3826-041 RIB/GUSSET ASSY**

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WITHOUT NOTICE  
WORK ORDER  
NO. 45506

**RELEASED**  
08/11/18

NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 2.59 lbs

A	NEW ISSUE	MB	08.09.23
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**D3826-041 RIB/GUSSET ASSY**

**RELEASED**  
8/11/18

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